

44

20-88

DART AEROSPACE LTD		Work Order:	19534
Description: Long Step Assembly – High Skid, RH D350-591-212	Part Number:	704A 41 640 007	
Dwg: D3070 Rev. A1 RF 02-11-13	Qty:	105	
			Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	HD	03-08-27	10
2	DC	Photocopy bluefile and type labels per PPP 704A 41 640 007 CHG001 CHG 001 WK 42	HD	03-10-07	10
3	GA	Cut D2622-120C extrusion to 116.25" long as per Dwg D3070 using cutting table setup DT8185-2A Pick: Qty Part Number Description Batch 1 D2622-120C Extrusion B18809 ml 04-02-02 5 Ensure wall thickness is 0.070 to 0.090			
4	GA	Drill extrusion per Dwg D3070 using Jig DT8680 for rivets.	ml	04-02-02	5
5	GA	Deburr	ml	04-02-02	5
6	QC5	Inspect work to Step 5	BB	04-02-02	5
7	WA	Bevel end for welding FWD ONLY	MM	04/02/06	5
8	WA	Weld Support using Jig DT8681, weld Fwd End Plate per QSI 004 & Dwg D3070 Pick: Qty Part Number Description Batch 1 D3063-1 Support B19555 MM 04/02/06 5 1 D3067-1 End Plate B19558 A/R Aluminum Rod M13066			
9	GA	Grind End Plate flush	MM	04/02/06	5
10	QC9	Inspect weld and work to Step 9	BB	04-02-11	5
11	FP	Chemical conversion coat as per QSI 005 4.1	2	04-02-13	5
12	GA	Assemble Leg Assembly as per Dwg D3070. D3066-1 are done Pick: with Step Leg Assy, don't add to the BOM. RF 03-01-13 Qty Part Number Description Batch 1 D3065-041 Step Leg Assy B19557 2 D3066-1 Spacer B19558 16 MS20600AD4W4 Rivet M13767	BB	02/04/16	5
13	QC5	Inspect work to step 12	MM	04/02/16	5
14	WA	Bevel Aft end for welding	MM	04/02/16	5
15	WA	Inspect for foreign object per QSI 024	MM	04/02/16	5
16	WA	Weld Aft End Plate per QSI 004 & Dwg D3070 Pick: Qty Part Number Description Batch 1 D3067-1 End Plate B19558 A/R Aluminum Rod M13066	MM	04/02/16	5

BB 04-02-25/08

CANCELLED 03-01-16
UNDER REVIEW
03-06-06 RF
See Drawing

RELEASED
02/11/16 RF

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial						

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____ Date: _____

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Description: Long Step Assembly – High Skid, RH D350-591-212	Part Number:	704A 41 640 007
Dwg: D3070 Rev. A 1	Qty:	105
		Page 2 of 2

17	GA	Grind End Plate flush	SD	04/02/19	5																																																				
18	QC9 & 5	Inspect work to Step 17 – Check dimension 110.56" from Dwg D3070 110.71" RF 02-11-13	SD	04-02-20	3																																																				
19	FP	Powder Coat Gloss White (Ref: 4.3.5.1) per QSI 005 4.3	2	04-02-23	5																																																				
20	FP	Wing Walk per Dwg D3070 and QSI 005 4.4	MM	04-02-23	5																																																				
21	QC3	Inspect Powder Coat and Wing Walk	SD	04-02-24	5																																																				
22	KP	Pick: Packing Kit <table border="1"><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>4✓</td><td>D2182B035</td><td>Rubber Cushion</td><td>B19540</td></tr><tr><td>8✓</td><td>D2274</td><td>Radius Block</td><td>B20207</td></tr><tr><td>2✓</td><td>D2856-400-720</td><td>Abrasion Strip</td><td>B18972</td></tr><tr><td>2✓</td><td>D3064-1</td><td>Clamp</td><td>A20123</td></tr><tr><td>1✓</td><td>D3070-041</td><td>Support Assy</td><td>B200510</td></tr><tr><td>4✓</td><td>D3080-1</td><td>Clamp</td><td>B19559</td></tr><tr><td>2✓</td><td>AN3-35A</td><td>Bolt</td><td>M13943</td></tr><tr><td>10✓</td><td>AN4-11A</td><td>Bolt</td><td>M13735</td></tr><tr><td>4✓</td><td>AN960JD10</td><td>Washer</td><td>M13719</td></tr><tr><td>20✓</td><td>AN960JD416</td><td>Washer</td><td>M13719</td></tr><tr><td>2✓</td><td>MS21042L3✓</td><td>Nut (or -3)</td><td>M14019</td></tr><tr><td>10✓</td><td>MS21042L4✓</td><td>Nut (or -4)</td><td>M13276</td></tr></tbody></table>	Qty	Part Number	Description	Batch	4✓	D2182B035	Rubber Cushion	B19540	8✓	D2274	Radius Block	B20207	2✓	D2856-400-720	Abrasion Strip	B18972	2✓	D3064-1	Clamp	A20123	1✓	D3070-041	Support Assy	B200510	4✓	D3080-1	Clamp	B19559	2✓	AN3-35A	Bolt	M13943	10✓	AN4-11A	Bolt	M13735	4✓	AN960JD10	Washer	M13719	20✓	AN960JD416	Washer	M13719	2✓	MS21042L3✓	Nut (or -3)	M14019	10✓	MS21042L4✓	Nut (or -4)	M13276	SD	04-02-24	5
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23	QC4	Inspect 100% Kit for Completeness on the W/O	SD	04-02-24	5																																																				
24	PK	Package for shipping as per PPP 704A 41 640 007	SD	04-02-24	5.																																																				
25	AC	Cost / part 243.62	SD	04-02-25	5																																																				
26	DC	Close W/O 243.62 Inspect Level 21	SD	04-02-26	5																																																				

Rev	Date	Change	Revised By	Approved
A	02.11.01	New issue	KJ RF	✓
A1	03.01.14	110.71" WAS 110.56" ; Dwg. Rev. A1	RF	✓
A2	03-07-16	D3194-0411 WAS D3070-0411 CHG002	RF	✓

UNDER REVIEW
03-09-06 RF
See Dwg. 01
CANCEL RF 03-01-16

RELEASED
02/11/02

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

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PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
HawkesburyAug 27, 2003
02:05 pm

Work Order No : 0019534
 Project Name : *704A 41 640 007
 Project For : wk344
 Work Order Type : Main
 Main WO Number :
 House Part Number : *704A 41 640 007
 Description : Heli-Access-Step, Long RH
 Manufactured : Yes
 Amount Req'd : *105*
 Amount Done : 0
 Start Date : 08-27-03
 Est Finish Date : 11-06-03
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Testing Hours	0.00	0.00	0.00	0.00	
Testing Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
SubContract Hours	0.00	0.00	0.00		
SubContract	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00